

Work Order ID 87005

Monday, July 09, 2012 2:36:02 PM

87005

Page 1

Item ID: D4626-1

Accept

N900040100

Setup Start ***NS1***

Revision ID: PRELIM

Item Name: Extension Spring (Lee Spring)

Stop ***NS2***

Start Date: 7/9/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/2012 Req'd Qty: 10.00

10

Customer:

Reference:

PRELIMINARY ISSUE

Approvals: Process Plan: *mf*

Date: *12-09-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4626	Revision Nbr <i>Rev A</i>								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <i>17399</i>								
	Make as per dwg								
	Possible Supplier: LEE SPRING								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

CH 12/07/10 (10)

11/2/10 (10)

10

DAS 15

13221

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87005

87005

Page 2

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Required Date: 7/20/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

CA

0.00

130

Packaging

Memo

0.00

Packaging

WKE

B-3-12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/3/12

WKE

B-3-12

POSITIVE RECALL
EFFECTIVE *12-7-10* AUTH *LR*
RELEASED *DAS* DATE *13/3/12*
16
9-89

to Rev A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 09, 2012 2:36:02 PM

Page 1

Work Order ID: 87005

Parent Item: D4626-1

Parent Item Name: Extension Spring (Lee Spring)

Start Date: 7/9/2012

Required Date: 7/20/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-07-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
LE 045D 05 S EXTENSION SPRING		Purchased	No				Each	7.0000		10		6/12/12	(10)

Location

Loc Qty

Loc Code

ST391

7

120157

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAFT

SPECIFICATION CONTROL DRAWING

DRAFT

DRAFT

DRAFT

DRAFT

DRAFT

DRAFT

DRAFT

1.50 REF
(FREE LENGTH)0.045 REF
(WIRE DIA.)Ø 0.38 REF
(O.D.)

DRAFT

DRAFT

D4626-1 SPRING

DRAFT

DRAFT

DRAFT

DRAFT

DRAFT

- NOTES:
- 1) MATERIAL: 301/304 STAINLESS STEEL, Ø0.045, PER ASTM A313
 - 2) FINISH: PASSIVATE PER ASTM A987
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: BAG AND IDENTIFY SHOWING DART P/N "D4626-1" AND BATCH NUMBER "BXXXXX"
 - 7) WEIGHT: LESS THAN 0.01 lbs
 - 8) PREFERRED SUPPLIER: LEE SPRING, BROOKLYN, NY. MANUFACTURER'S P/N LE 045D 05 S

A		NEW ISSUE		AP	12.06.13
REV.		DESCRIPTION		BY	DATE
Revision Table					
DESIGN		RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		RP			
CHECKED		ASS	DRAWING NO.		REV. A
MFG. APPR.		CS	D4626		SHEET 1 OF 1
APPROVED		W	TITLE		SCALE
DE APPR.		#	EXTENSION SPRING		NTS
DATE		12.06.13			
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17399**

Purchase Order Date 7/10/12

PO Print Date 7/10/12

Page Number 1 of 1

Order From :

VU-ROY001

VISA

PAYMENT CENTRE, PO BOX 4016, STAT. A
TORONTO,

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

COD

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FAKED
C012072

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	LE 045D 05 S	EXTENSION SPRING	7/13/12 Yes	10.00 Each	FedEx PI collect	\$6.0400	\$60.40

Special Inst: AS PER DWG D4626 REV. A
B87005
LEE SPRING P/N: LE 045D 05 S

PO Total:

\$60.40

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

PO Instructions: LEE SPRINGS
VISA ACCT: 4514 0310 0909 0347 EXP DATE: 11/13

Change Nbr: 1

Change Date: 7/10/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

IMPORTANT DOCUMENT! FORWARD TO QUALITY DEPT.



Lee Spring®

Phone: 888-777-4647

Fax: 888-426-6655

NY - CT - AZ - NC - MO

CERTIFICATE OF COMPLIANCE

We hereby certify that the item (s) indicated on the attached Packing List is (are) in Conformance with this Purchase Order.

This order was shipped out of Lee Spring's Stock Spring Inventory.

All Lee Spring Stock Springs are certified to be RoHS and REACH compliant.

All Lee Spring Stock products are Mercury Free.

Material Code "S" or "SS" signifies Stainless Steel 302 or 304 or 17-7 pH

Material Code "S316" signifies Stainless Steel 316

Material Code "M" or "MW" signifies Music Wire

Stainless Steel Wire

Type 301/302/304 and Type 316 per ASTM A313, A666, AMS A5906, JIS-G-4305-2005,

SUS301, SUS302, SUS631, DIN 17224, BS 2056, EN 10270-3 or JIS-G-4314

Type 17-7pH per AMS 5529, ASTM A313 or JIS G-4314

Music Wire

ASTM A228, DIN 17223, BS 5216, EN 10270-1 or JIS-G-3522

Other

Oil Tempered MB per ASTM A229, DIN 17223, BS 2803 or EN 10270-2

Oil Tempered Chrome Silicon per ASTM A401, DIN 17223, BS 2803 or EN 10270-2

Elgiloy per AMS 5833 (Chemical Only)

Beryllium Copper per ASTM B197

Utem PEI Resin (Plastic Composite) per SABIC Standard

All Stock Lee Music Wire springs are Zinc Plated per ASTM B633

All Stock Lee Stainless Steel 302/304/17-7pH springs are Passivated per ASTM A967

All Stock Lee Stainless Steel 316 springs are Ultrasonic Passivated per ASTM A967

The contents of this shipment are Non-Traceable.

Thank you,

Elvis Jarvis
Quality Assurance Manager

LEE SPRING COMPANY

104 Industrial Avenue
Greensboro, NC 27406

Packing Slip

Ship To Address:

DART AEROSPACE

PO# P017399 / 613 632 9577

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7: CANADA

Ship Via: Z SEE ORDER

Sales Order: 386638

P.O. # P017399

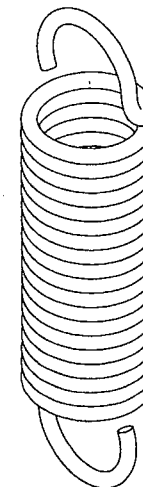
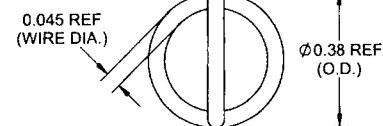
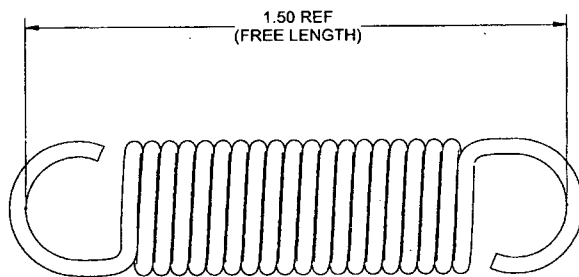
Date: 07/17/12

Opr. LD

Loc. NC LS505

Ln	Stock Code	Rev	Shipped	B/O
1	LE 045D 05 S 04626 / B87005	NR	10.000	0.000

SPECIFICATION CONTROL DRAWING



D4626-1 SPRING

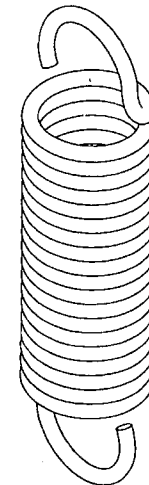
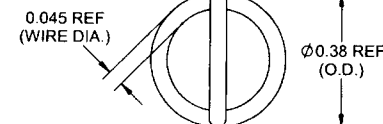
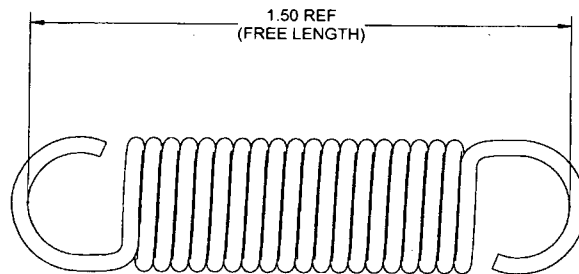
NOTES:

- 1) MATERIAL: 301/304 STAINLESS STEEL, Ø0.045, PER ASTM A313
- 2) FINISH: PASSIVATE PER ASTM A967
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: BAG AND IDENTIFY SHOWING DART P/N "D4626-1" AND BATCH NUMBER "BXXXXX"
- 7) WEIGHT: LESS THAN 0.01 lbs
- 8) PREFERRED SUPPLIER: LEE SPRING, BROOKLYN, NY. MANUFACTURER'S P/N LE 045D 05 S

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Revision Table			
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	CS	D4626	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.		EXTENSION SPRING	NTS
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87005 RELEASE
2012-09-18

SPECIFICATION CONTROL DRAWING



D4626-1 SPRING

RELEASE
2012-09-18

- NOTES:**
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APPROVED	W	TITLE	SCALE
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	---	---	--	---